

Date: Tuesday, 1/9/2007 4:06:38 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 30212	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 1/9/2007 S.O. No. : N/A	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 30094	Material : N/A
Written By : <u>JA</u>	Due Date : 1/30/2007 Qty: 12 Um: Each
Checked & Approved By : <u>JA 07.01.09</u>	
Comment : Est: 1 02/10/02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: B05354

JA 07/01/22

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 30212 Double check by: JA

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

JA 12.8 07/01/22 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

JA 12.8 07/01/22 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 12.8 07/01/22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial - Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:38 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30212

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/01/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX/

07/02/01

(12)

7.0

POWDER COATING

POWDER COATING



M103141



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h/yl

07/02/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/02/06 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1472

07/02/06 (12x) C

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/07

Job Completion



U 07.02.07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30212
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	Ø.440"	Ø.440"	Ø.440"		
B	1.745	1.755		1.750	1.749	1.749	1.750		
C	3.495	3.505		3.500	3.500"	3.501	3.500		
D	1.745	1.755		1.750	1.749"	1.749	1.750		
E	7.990	8.010		8.000	8.004"	8.002	7.999		
F	0.490	0.510		.500	.501"	.503	.505		
G	0.257	0.262	DT8683	.258	Ø.260"	Ø.260	Ø.260"		
H	0.375	0.380	DT8684	.375	Ø.376"	Ø.376"	Ø.376"		
I	0.490	0.510		.501	.505"	.506"	.505		
J	1.174	1.184		1.182	1.181"	1.181"	1.180		
K	0.558	0.578		.569	.570"	.570"	.570		
L	1.174	1.184		1.182	1.181"	1.181"	1.181		
M	1.490	1.500		1.496	1.499"	1.499"	1.499		
N	2.495	2.505		2.501	2.502"	2.502"	2.502		
O	3.869	3.879		3.875	3.877"	3.877"	3.877		
P	0.115	0.135		.124	.123"	.122"	.122		
Q	0.115	0.135		.128	.125"	.125"	.135		
R	0.240	0.260		.254	.251"	.149"	.149		
S	0.115	0.135		.121	.130"	.130"	.130		
T	0.178	0.198		.188	Ø.188"	Ø.188"	Ø.188		
U	2.940	2.980		2.960	2.963"	2.963"	2.963		
V	0.230	0.250		.240	.243"	.244"	.244		
W	0.115	0.135		.124	.123"	.125"	.125		
X	0.308	0.313		.312"	.312"	.310	.310		
Y	0.760	0.765		.764"	.764"	.764	.764		
Z	0.352	0.372		.372	.367"	.360	.360		
AA	0.470	0.530		.500	Ø.500"	Ø.500	Ø.500		
AB	0.615	0.635		.625"	.625"	.625"	.625		
AC	0.053	0.073		.063	.063"	.063"	.063		
AD	0.240	0.260		.250	.249"	.249"	.249		
AE	1.375	1.395		1.386	1.388"	1.386"	1.387"		
AF	0.115	0.135		.125	.125"	.130"	.130		
AG	0.240	0.280		.252	.250"	.249	.249		
AH	0.240	0.260		.252	.251"	.251"	.251		
AI	2.000	2.020		2.001	2.000"	2.001"	2.002"		
AJ	0.023	0.043		.025	.025"	.025"	.025		
Accept/Reject									

Measured by: S.F. / J.F.
Date: 07/01/23

Audited by: E
Date: 07/01/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	30212
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

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				1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.003	8.003		
F	0.490	0.510		.500	.506	.502	.499		
G	0.257	0.262	DT8683	.258	.259	.258	.258		
H	0.375	0.380	DT8684	.376	.375	.375	.375		
I	0.490	0.510		.508	.502	.507	.501		
J	1.174	1.184		1.180	1.180	1.178	1.178		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.872	3.872		
P	0.115	0.135		.122	.121	.121	.121		
Q	0.115	0.135		.128	.128	.121	.121		
R	0.240	0.260		.252	.250	.251	.251		
S	0.115	0.135		.134	.125	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.964	2.960	2.962	2.962		
V	0.230	0.250		.245	.240	.248	.248		
W	0.115	0.135		.128	.128	.126	.126		
X	0.308	0.313		.310	.312	.312	.312		
Y	0.760	0.765		.760	.764	.764	.764		
Z	0.352	0.372		.360	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.626	.627		
AC	0.053	0.073		.060	.060	.063	.063		
AD	0.240	0.260		.250	.250	.250	.248		
AE	1.375	1.395		1.385	1.385	1.386	1.385		
AF	0.115	0.135		.125	.125	.130	.130		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.253	.251		
AI	2.000	2.020		2.001	2.001	2.000	2.001		
AJ	0.023	0.043		.043	.043	.023	.023		
Accept/Reject									

Measured by:	J.F. / S.F.
Date:	07/01/27

Audited by:	En
Date:	07/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>30212</b>
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B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.003"	8.003"	8.003"	8.003"		
F	0.490	0.510		0.501"	0.501"	0.501"	0.501"		
G	0.257	0.262	DT8683	0.260"	0.260"	0.260"	0.260"		
H	0.375	0.380	DT8684	0.376"	0.376"	0.376"	0.376"		
I	0.490	0.510		0.502"	0.502"	0.503"	0.503"		
J	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
K	0.558	0.578		0.568"	0.570"	0.570"	0.570"		
L	1.174	1.184		1.179"	1.179"	1.179"	1.179"		
M	1.490	1.500		1.495"	1.495"	1.495"	1.495"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		0.123"	0.124"	0.123"	0.123"		
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.251"	0.251"	0.251"	0.250"		
S	0.115	0.135		0.130"	0.130"	0.130"	0.130"		
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
U	2.940	2.980		2.962"	2.962"	2.962"	2.962"		
V	0.230	0.250		0.246"	0.245"	0.244"	0.244"		
W	0.115	0.135		0.126"	0.127"	0.125"	0.130"		
X	0.308	0.313		0.312"	0.312"	0.312"	0.312"		
Y	0.760	0.765		0.764"	0.764"	0.764"	0.764"		
Z	0.352	0.372		0.367"	0.363"	0.363"	0.363"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.629"	0.627"	0.625"	0.625"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.252"	0.255"	0.250"	0.250"		
AE	1.375	1.395		1.385"	1.385"	1.386"	1.386"		
AF	0.115	0.135		0.130"	0.130"	0.130"	0.130"		
AG	0.240	0.280		0.250"	0.250"	0.250"	0.250"		
AH	0.240	0.260		0.253"	0.255"	0.250"	0.251"		
AI	2.000	2.020		2.001"	2.001"	2.001"	2.000"		
AJ	0.023	0.043		0.023"	0.023"	0.023"	0.023"		
Accept/Reject									







Measured by:	J.F. / J.F.
Date:	07/01/29

Audited by:	E
Date:	07/01/29

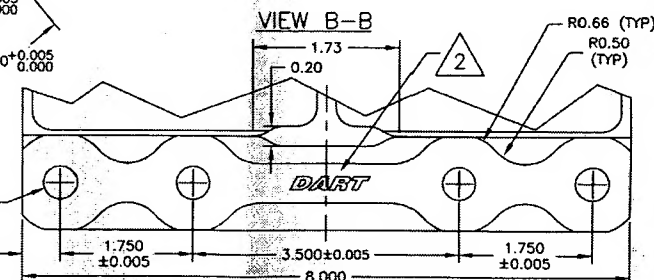
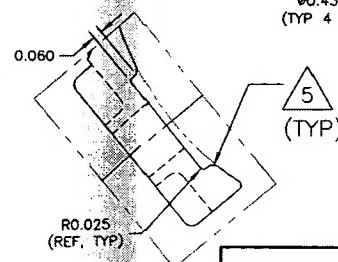
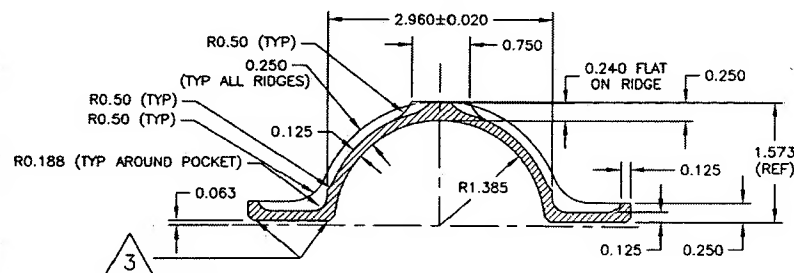
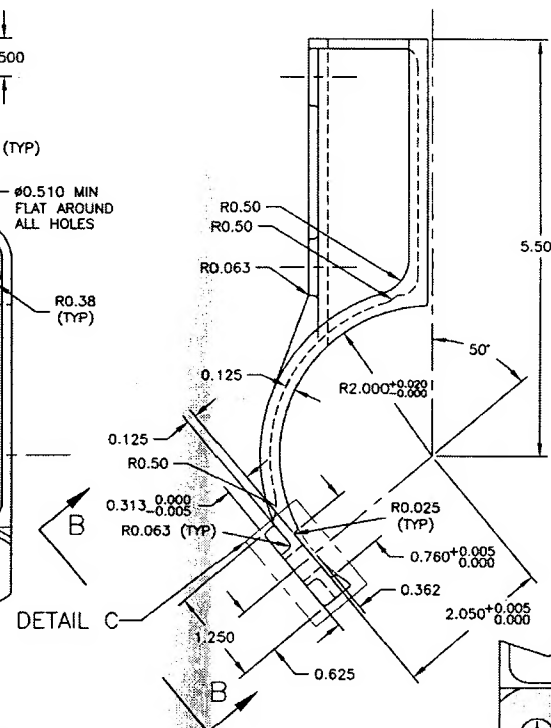
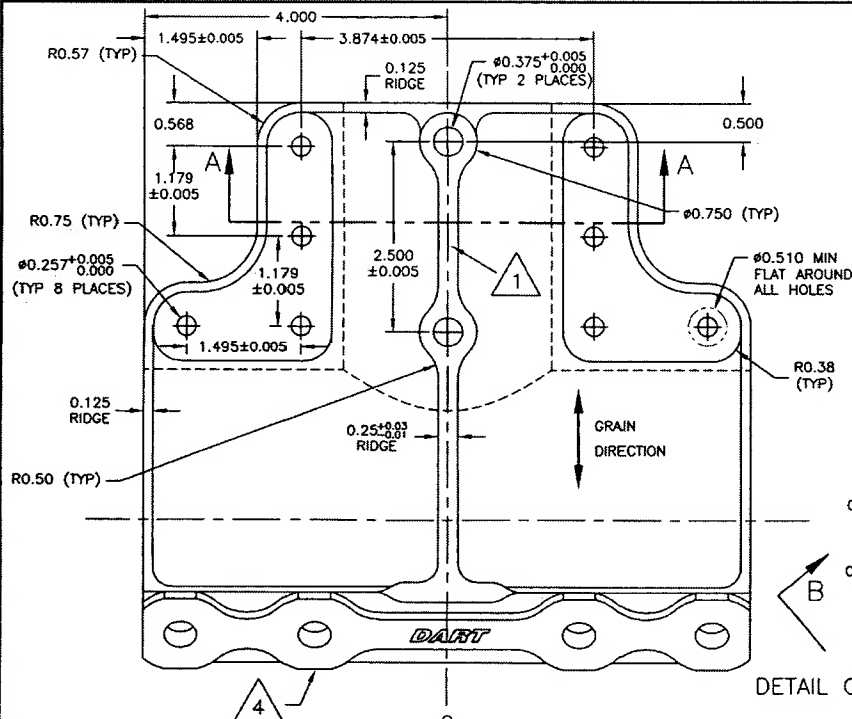
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

$\triangle E$



SECTION A-A

DETAIL C  
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS	DRAWN BY PH	 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. <b>D2571</b>
DATE 05.07.13	TITLE OUTER FWD SADDLE	

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NO. 30212